

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004022**Date Inspected:** 18-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng, Jiang Jian Fei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** tower skin assemblies,deck panels**Summary of Items Observed:**

Tower shop - Bay 1

QA Inspector randomly observed approximately 50 ZPMC workers performing the following: heat straightening of plates with oxy-fuel torches; oxy-fuel cutting of bevels; grinding of cover pass on stiffener to SSD1-skin B assembly and SSD1-skin D assembly; drilling of 30mm holes in stiffeners. Also present in this bay were ZPMC CWI's Xu Le Feng as well as ABF QC's Yang Yi Heng, C. K. Chan, Jiang Zi Wen. Items observed appeared to comply with project specifications.

Tower shop - Bay 2

QA Inspector randomly observed approximately 55 ZPMC workers performing the following: FCAW-G automatic cover passes with four welders southwest gantry on stiffener to ESD1-skin C assembly; flame heat straightening of ESD1-E assembly using jacks; bevel cutting of plates; SAW of skin plate and stiffeners. Also present in this bay were ZPMC CWI's Jiang Jian Fei and Zhu Zhong Hai as well as ABF QC Zhang Da Ming and Xing Xiao Guang. Items observed appeared to comply with project specifications.

Heavy Duty Machine Shop – Bay 3

QA Inspector randomly observed no ZPMC workers in this bay. There were 17 full size panels and several unidentified deck plates in various stages of butt welding present in the bay. Items observed appeared to comply with project specifications.

WELDING INSPECTION REPORT

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Summary of Conversations:

No significant conversations this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer